

Date: Tuesday, 11/29/2005 6:53:18 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INNER FWD SADDLE
Job Number : 25043
Estimate Number : 11079
P.O. Number : N/A
This Issue : 11/29/2005 S.O. No. N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : N/A
Written By :
Checked & Approved By :
Comment : Created By Auto Work Order

Part Number : D5953
Drawing Number : D5953 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 11/29/2005 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: _____

B25354 x2
B25353 x2 x4 En 06/11/07

Tools:

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered I.L.
B25043

2-Machine Keyway PTO

3-Deburr & Tumble

En 06/11/08 x4

Tools:

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

En 06/11/08 x4

Tools:

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/11/08

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED (V). SIMILAR TO 02521 SEE ATTACHED	PH 06.11.03				 06.11.03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 6:53:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 25043

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

gle 06/11/08 x 4

Tools:

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06 12 11 (4)

Tools:

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Tools:

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PV 4/11/13 (4)

Tools:

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(4)

Tools:

06/11/13

Job Completion



CZ 06/11/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Inner Fwd Saddle	Part Number:	D5953
Inspection Dwg: D5953 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5953 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.750	1.748		
C	5.245	5.255		5.248	5.251	5.254	5.249		
D	6.995	7.005		7.002	7.001	7.003	7.002		
E	5.745	5.755		5.742	5.748	5.748	5.748		
F	4.745	4.755		4.748	4.748	4.749	4.749		
G	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
H	1.522	1.532		1.527	1.529	1.530	1.527		
I	3.048	3.058		3.053	3.054	3.055	3.055		
J	4.575	4.585		4.579	4.578	4.579	4.580		
K	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
L	0.240	0.260		0.248	0.250	0.255	0.255		
M	0.490	0.510		0.502	0.499	0.500	0.498		
N	0.240	0.260		0.251	0.251	0.251	0.250		
O	7.990	8.010		8.001	8.003	8.003	8.003		
P	0.240	0.260		0.248	0.248	0.249	0.247		
Q	0.307	0.312		0.311	0.311	0.310	0.311		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.497	0.499	0.495	0.499		
T	1.375	1.395		1.383	1.380	1.380	1.379		
U	2.000	2.020	DT8696 A/B	2.000	2.000	2.000	2.000		
V	0.023	0.043		0.030	0.030	0.030	0.030		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	En
Date:	06/11/08

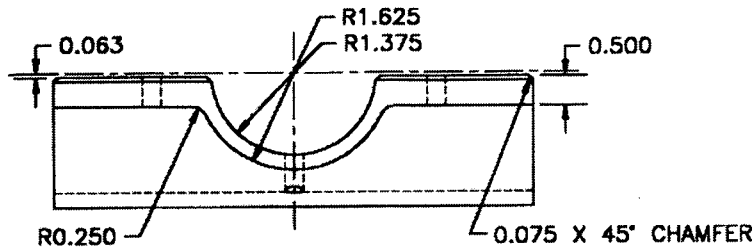
Audited by:	ml
Date:	06/11/08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

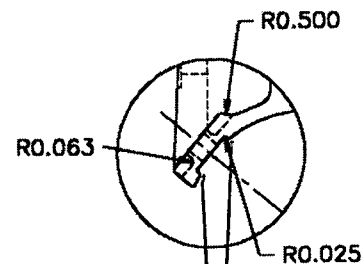
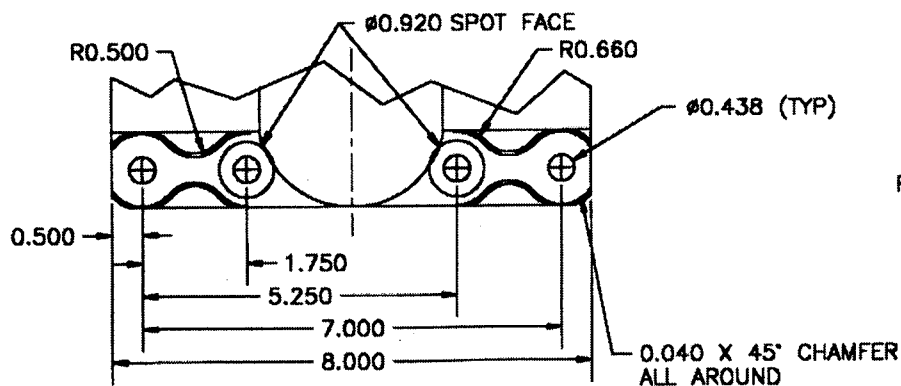
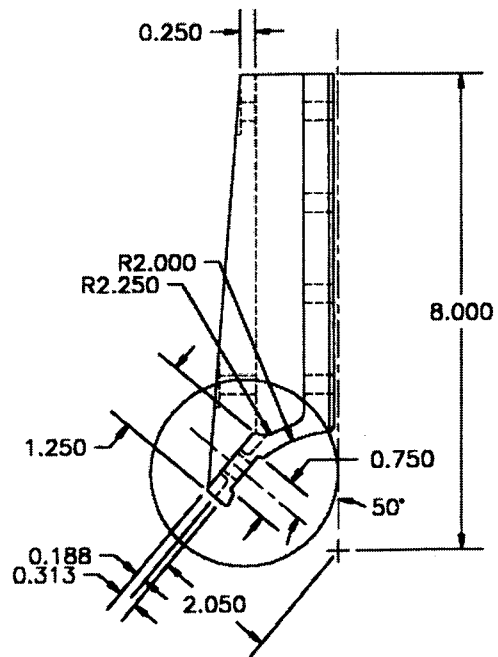
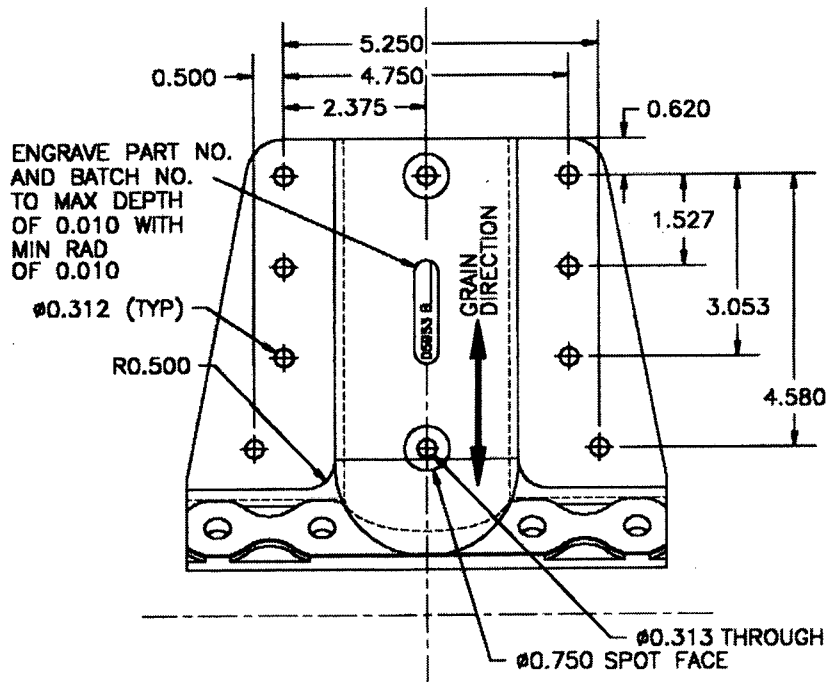
DART

DESIGN <i>BW</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D5953	REV. A SHEET 1 OF 1
DATE 97.05.06	TITLE INNER FWD SADDLE		SCALE

MATERIAL: ~~7075-T651~~ OR 7075-T7351 QQ-A-250/12
FINISH: ACID ETCH, ALODINE, PER QSI 005 4.1
PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2
BREAK ALL SHARP EDGES 0.010 TO 0.020

**RELEASED**
97/05/14 DS

EFFECTIVE	DEOs
9102	9079
98/05/04 DS	98/06/22 DS



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CHAMFER
0.033 X 45° (TYP)
PH
06.11.03

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 10:22 AM
To: 'Peter Hum'
Subject: RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, November 02, 2006 2:33 PM
To: 'David Shepherd'
Subject: D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

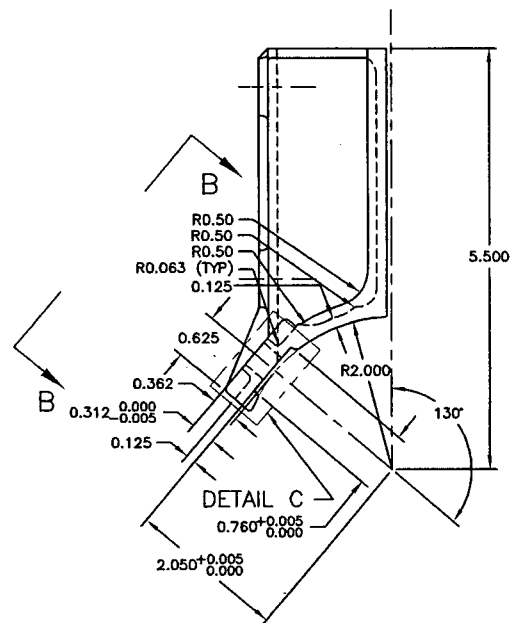
Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

Peter

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

03/11/2006



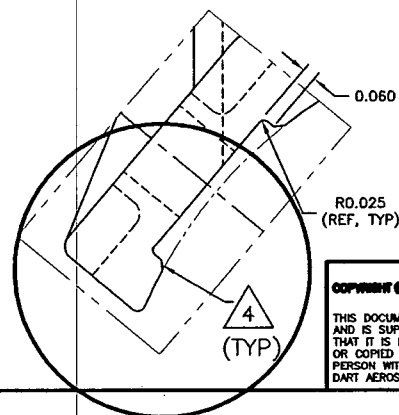
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALØDINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

REFERENCE ONLY

REFERENCE ONLY



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE INNER AFT SADDLE
		DRAWING NO. D2574
		REV. E SHEET 1 OF 1 SCALE 2:3

DART DART AEROSPACE LTD.
WARRICKBURT, ONTARIO, CANADA